

Work Order ID 62681

Wednesday, October 06, 2010 2:58:06 PM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

15.00

Start Date: 10/6/2010 Start Qty: ~~8.00~~



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: ~~8.00~~



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/06/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

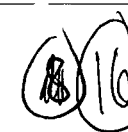
Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B10-10-05



SL 10/11/10

SL 10/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2432 PAR #: _____ Fault Category: machining NCR: Yes No DQA: [Signature] Date: 10/11/18
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/11/18

NCR: 62681		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/15	120	- 1 part was cut crooked on waterjet, was not able to machine on HAAS due to deep groove	[Signature]	- SCRAP + no replace	[Signature]	SL 10/11/17	[Signature]	[Signature]
		2nd order: Employee on w.jet was not aware it would not be machined off.	/	/	/	/	/	/

NOTE: Date & initial all entries

Work Order ID 62681

Wednesday, October 06, 2010 2:58:06 PM

Page 2

Item ID: D2432

Accept

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 10/6/2010 Start Qty: 8.00

Required Date: 10/15/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

aml 10/11/17

15

151

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PPP
63796

10/11/17 (15)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/17
BS 10-11-17
(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 2:58:10 PM

Page 1

Work Order ID: 62681



Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw


Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	194.0533	3.7	29.6 59.2			
UHMW 1" Black													

Location

MAT

Loc Qty

194.0533

Loc Code

113903

79.7473

114624

8.8

115325

105.506

115955

~~115325~~ = 29.6
~~115955~~ = 29.6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62681
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.070 x 45°	✓		Vern 2L-3	
B	5.500	+/-0.030	5.504	✓		"	
C	0.200	+/-0.030	.195	✓		"	
D	0.25 x 45°	+/-0.030	.255 x 45°	✓		"	
E	R0.250	+/-0.030	.250	✓		R-G	
F	0.250	+/-0.010	.254	✓		Vern 2L-3	
G	0.625	+/-0.030	.627	✓		"	
H	0.375	+/-0.010	.377	✓		"	
I	0.950	+0.030/0.010	.960	✓		"	
J	19.000	+/-0.030	19.00	✓		m-tape	
K	3.14	+/-0.030	3.140	✓		Vern 2L-3	
L	3.28	+/-0.030	3.280	✓		"	
M	Ø0.260	+0.005/-0.000	.259	✓		"	
N	Ø0.93	+/-0.030	.925	✓		"	
O	0.30	+0.030/-0.000	.315	✓		"	
P	23.750	+/-0.030	23.750	✓		m-tape	
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.380	✓			

Measured by:	<i>ll</i>	Audited by:	<i>Qmk</i>	Prototype Approval:	N/A
Date:	10/11/16	Date:	10/11/17	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF <i>af</i>	<i>af</i>

Dart Aerospace Ltd

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NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
93.06.17 KE

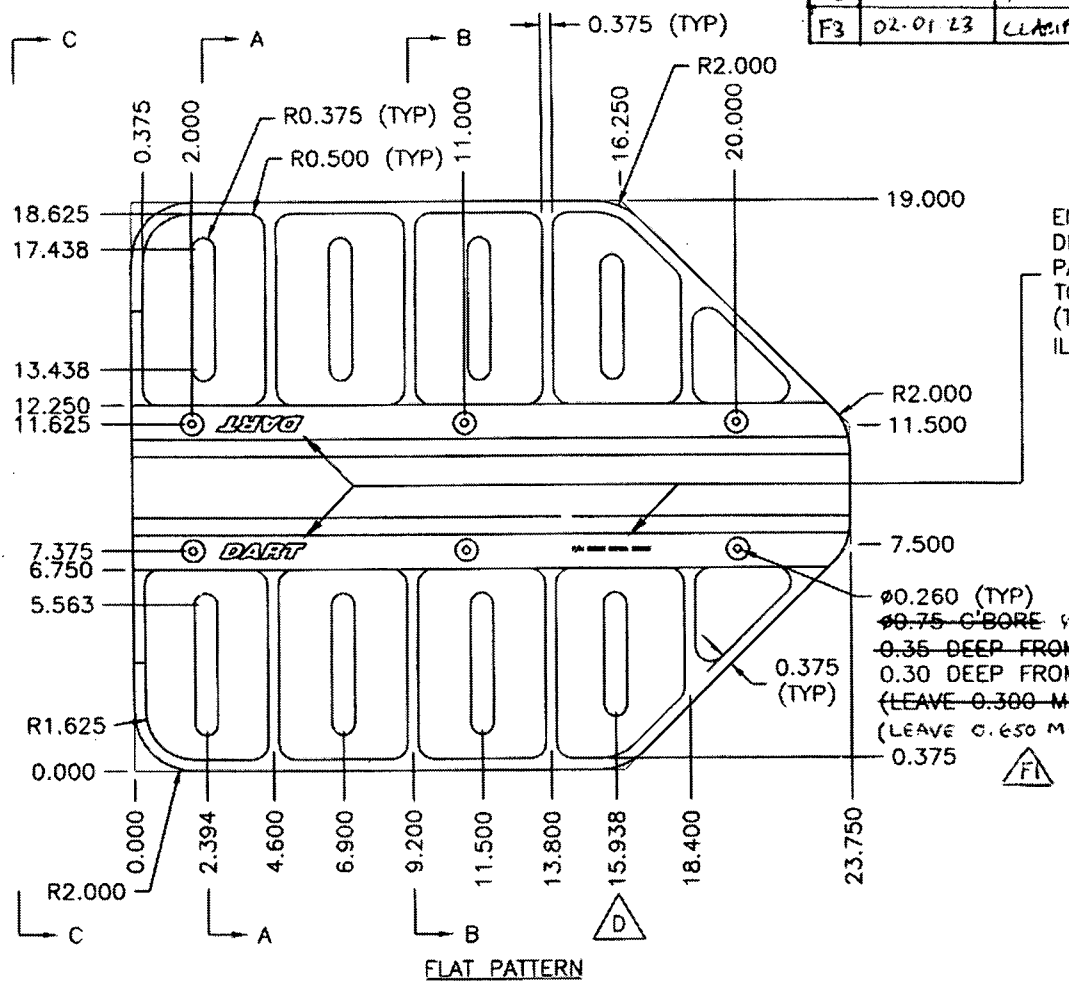
SHEET 1 OF 2

UNICOM
SUBJECT
V.I.
W.
NO. 101006



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	
DATE 98.05.12	TITLE	REVISIONS
	BEARPAW	
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N



EFFECTIVE DEOS
9143

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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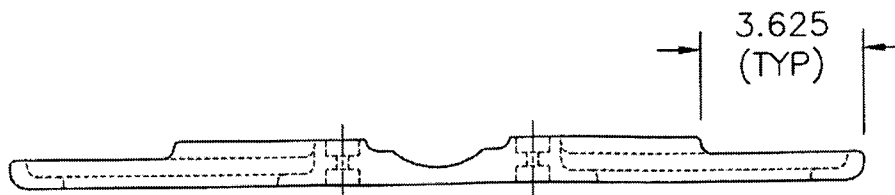
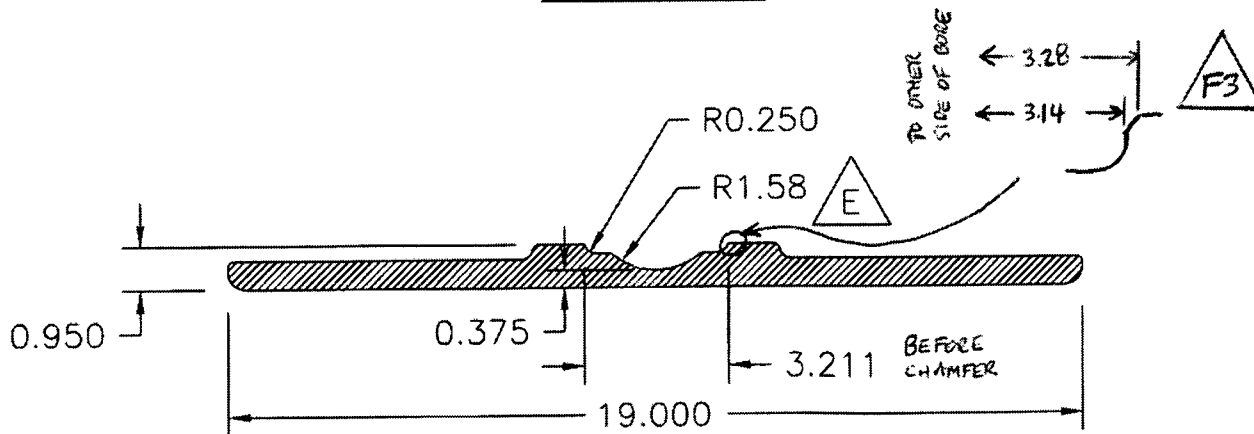
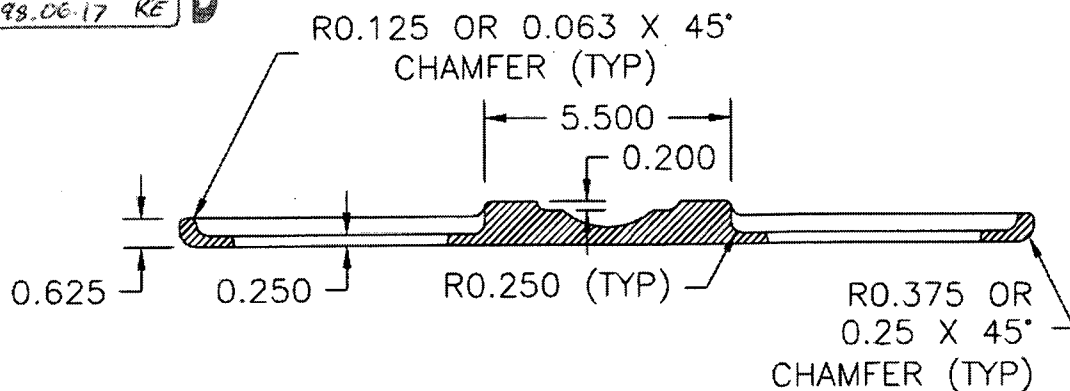
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE

wb62681



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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